

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015051**Date Inspected:** 10-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yang Bai Qiang.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Amit Juvekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Subassembly, Bay 09, 13BE, Continuity Stiffener inside U-Rib.

FCAW welding of Fillet weld Partial Penetration joint DP3087-001-106, 107, 116, 117; located on subassembly, Bay 09, 13BE. Welder is identified as 062259, 059403; ZPMC Quality Control Inspector (QC) is identified as Yong Bai Qiang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2133.

Subassembly, Bay 09, Deck Panel 13BW-DP3138-001.

This QA inspector performed conventional Ultrasonic Testing (UT) Inspection on deck panel tack weld areas. The inspection is preliminary prior to using the phased array (PAUT) testing system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel DP3138-001, 3 ribs, 6 welds, 54 total tack welds inspected.

Weld 5 scanned 9 locations with 1 indication.

Weld 6 scanned 9 locations with no indications.

Weld 7 scanned 9 locations with 1 indications.

Weld 8 scanned 9 locations with 4 indication.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Weld 47 scanned 9 locations with 2 indications.

Weld 48 scanned 9 locations with no indications.

Subassembly, Bay 12, Deck Panel 13BW-DP3138-001.

QA inspector performed conventional Ultrasonic Testing (UT) Inspection of approximately 10% for Lack of Penetration (LOP) on deck panel (U-rib to deck plate) Partial Penetration weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as Deck Panel. The weld designations reviewed are as follows

DP3138-001-005 to 008 & 47, 48.

Subassembly, Bay 09, Deck Panel 13BW-DP3136-001.

This QA inspector performed conventional Ultrasonic Testing (UT) Inspection on deck panel tack weld areas. The inspection is preliminary prior to using the phased array (PAUT) testing system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel DP3136-001, 05 ribs, 10 welds, 90 total tack welds inspected.

Weld 1 scanned 9 locations with 2 indication.

Weld 2 scanned 9 locations with 2 indications.

Weld 3 scanned 9 locations with no indications.

Weld 4 scanned 9 locations with no indication.

Weld 5 scanned 9 locations with no indications.

Weld 6 scanned 9 locations with 1 indications.

Weld 7 scanned 9 locations with 1 indications.

Weld 8 scanned 9 locations with 2 indications.

Weld 9 scanned 9 locations with 4 indications.

Weld 10 scanned 9 locations with 1 indications.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
